

Work Order ID 126182

126182

Page 2

Item ID: D3319-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Full-Length Wearplate

Start Date: 10/30/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/30/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(20)

DAS
38
9-89

NOV 03 2014

140

NC BRAKE

0.00

140

Brake NC

Memo

0.00

Brake NC

Form using DT8326 & DT8261 as per Dwg D3319Rev: C

DAS
30
9-89

20

41/10/05

150

QC6- Inspect dimensions to drawing

0.00

150

QC

Memo

0.00

Quality Control

(20)

DAS
38
9-89

NOV 04 2014
NOV 05 2014

NOV 05 2014

Work Order ID 126182

Thursday, October 30, 2014 9:56:37 AM

126182

Page 3

Item ID: D3319-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Full-Length Wearplate

Start Date: 10/30/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/30/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Weld per dwg A/R Hardcoat steel Batch: M130661 0.00
Large Fab

160

Large Fab

Memo

0.00

*10

15-02-26 MAL

Large Fab

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319
Batch A/R 7560 Hardcoat Rod M130661

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

10

15-3-2

DAS
50
9-89

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

10

15-3-2

DAS
9-89
50
9-89

Quality Control

Work Order ID 126182

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126182

Page 4

Item ID: D3319-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Full-Length Wearplate

Start Date: 10/30/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/30/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

190

m 128564.

10 15-3-2. DAS 34 9.89

Powdercoat

Memo

3.35.

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

3200

FINISH TIME:

4:05.

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

(10) 15-03-17.

**DAS
9
9-89**

210

Packaging

0.00

210

Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following:TCCA-PDA. Dart Aerospace Ltd.P/N: D3319-3. B/N: BXXXXXFor Product Eligibility see PDA05-18 and Stock

Location: *8T 603*

10x SP 15-03-17

Work Order ID 126182***126182***

Page 5

Item ID: D3319-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Full-Length Wearplate

Start Date: 10/30/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/30/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

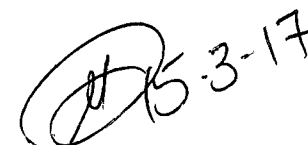
QC

Memo

0.00

Quality Control

MLJ 1503-17



Picklist Print

Thursday, October 30, 2014 9:56:44 AM

Page 1

Work Order ID: 126182

126182

Parent Item: D3319-3

D3319-3

Parent Item Name: Full-Length Wearplate

Start Date: 10/30/2014

Required Date: 10/30/2014

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: A05.05.12New issueKJ/JLM
IPP Rev:B Now on Waterjet 06-10-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased	No			100	sf	183.2709	3.2524	X 60		DAS 23 9-89	14-10-31
									**				

M1010S18GA

1010/1025 SHEET .048

Location

Loc Qty

Loc Code

MAT

100

m130454

100

MAT019

83.2709

116268

0.970948

117806

18

124428

31

m129674

33.3

130454

130454

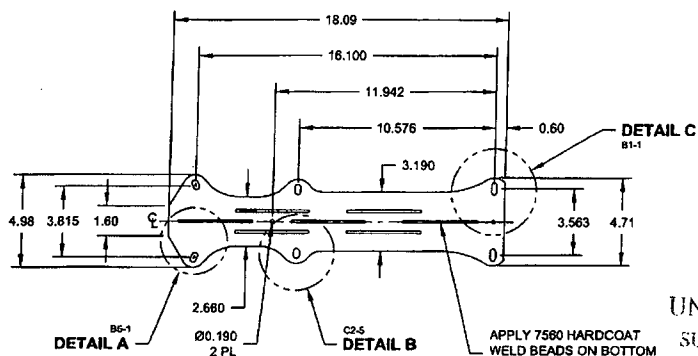
DART AEROSPACE LTD		Work Order:	126182
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.190	+0.005/-0.001	0.191"	-		V	Jkms.
Ø0.500	+0.006/-0.001	0.502"	-		V	
0.316	+/-0.010	0.318"	-		V	
0.607	+/-0.010	0.609"	-		V	
2.94	+/-0.030	2.94"	-		V	
2.69	+/-0.030	2.69"	-		V	
3.527	+/-0.010	3.527"	-		V	
4.52	+/-0.030	4.52"	-		V	
5.063	+/-0.010	5.063"	-		V	
6.16	+/-0.030	6.16"	-		V	
0.60	+/-0.030	0.60"	-		V	
8.690	+/-0.010	8.690"	-		V	Jkms.
30.790	+/-0.010	30.790"	-		T	Jkms.
52.88	+/-0.030	52.88"	-		T	
62.770	+/-0.010	62.770"	-		T	
74.420	+/-0.010	74.420"	-		T	
75.52	+/-0.030	75.52"	-		T	
0.050	+/-0.010	0.048"	-		V	

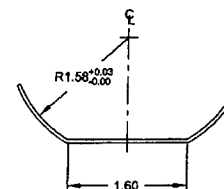
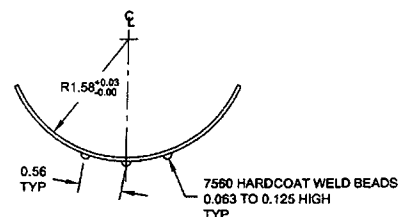
Measured by: DAS 23 9-89		Audited by: DAS 38 9-89		Preliminary Approval:	
Date: 14-10-31		Date: NOV 03 2014		Date:	

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	

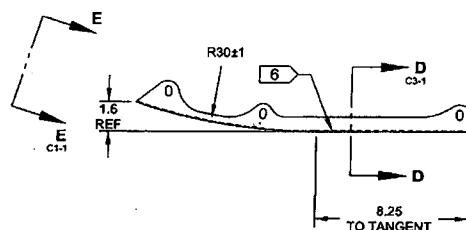


D3319-1F FLAT PATTERN

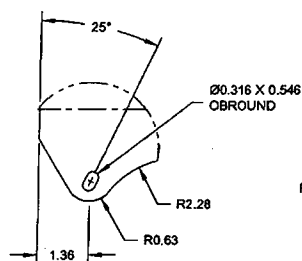
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 126182 MJS
14-10-30



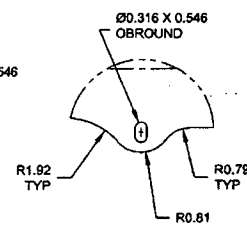
SECTION E-E
SCALE 4X



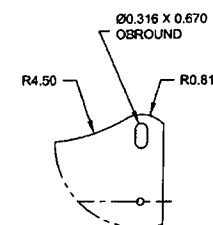
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



DETAIL A
SCALE 4X



DETAIL B
SCALE 4X



DETAIL C
SCALE 4X

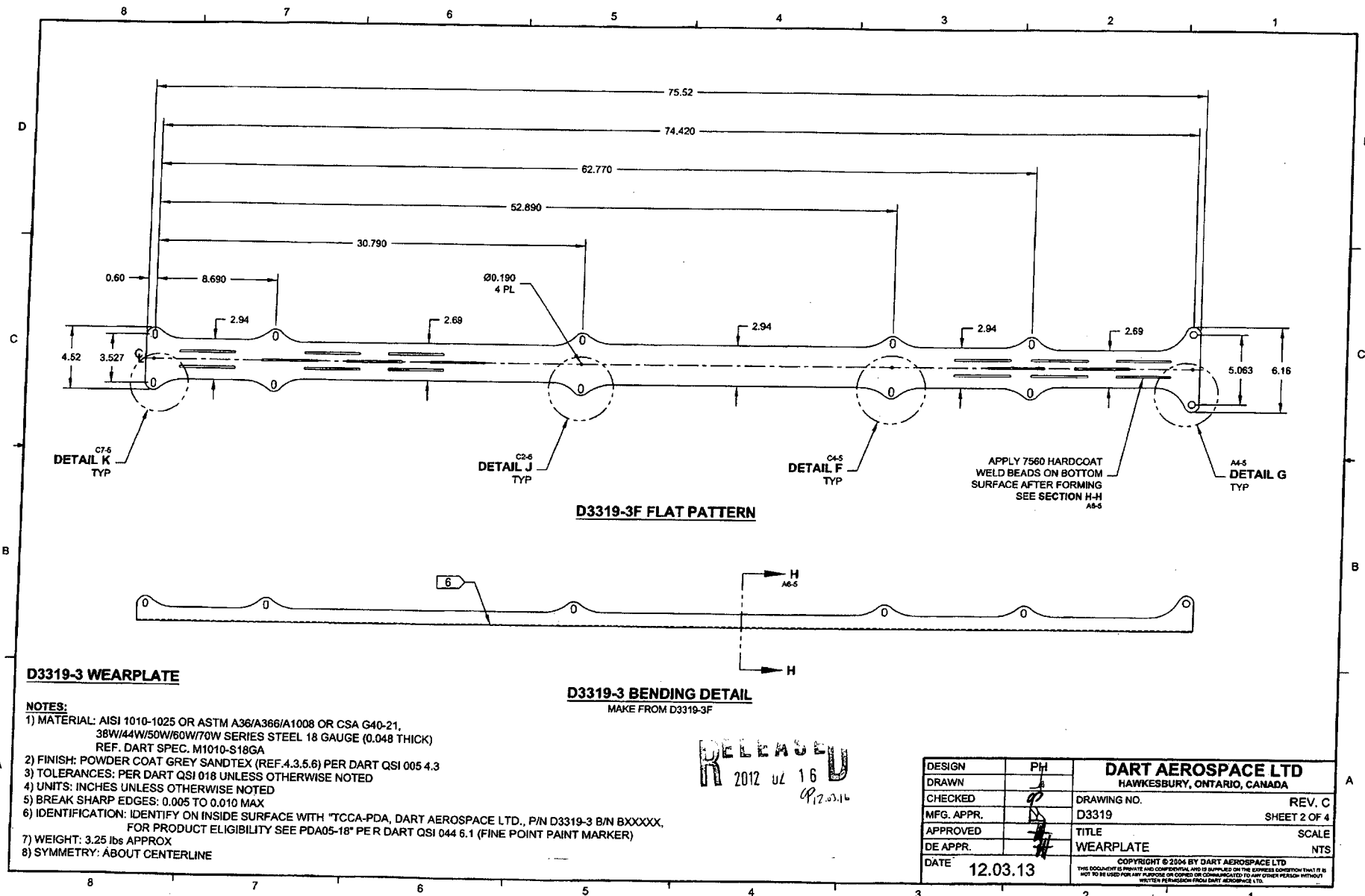
D3319-1 WEARPLATE

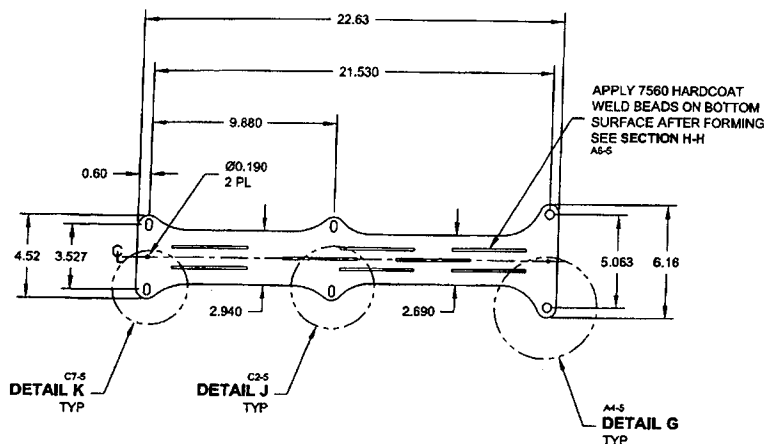
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

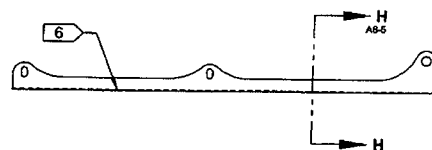
RELEASED
2012-03-16
PER ECN 12-546 12-3-16

C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT. MOST HOLE ON -3/-5/-7 (REF DETAIL G). SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/-5/-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. C D3319 SHEET 1 OF 4 TITLE SCALE WEARPLATE NTS COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	12.03.13		

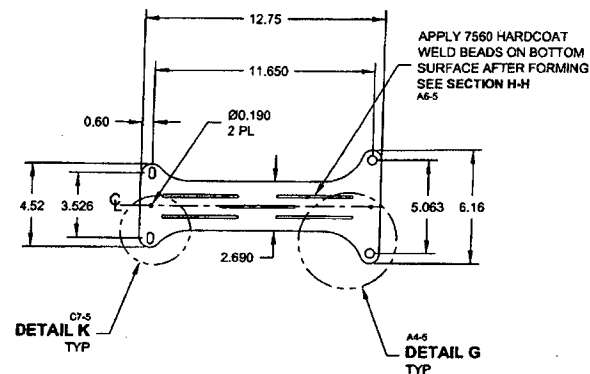




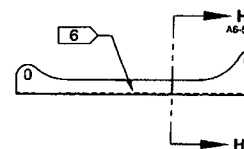
D3319-5F FLAT PATTERN



D3319-5 BENDING DETAIL
MAKE FROM D3319-5F



D3319-7F FLAT PATTERN



D3319-7 BENDING DETAIL
MAKE FROM D3319-7F

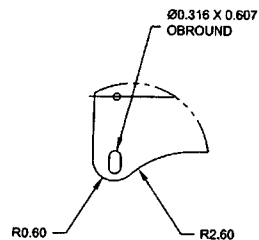
D3319-5/-7 WEARPLATE

NOTES:

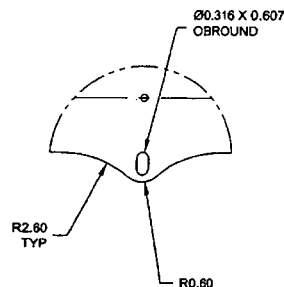
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-02-16
4120316

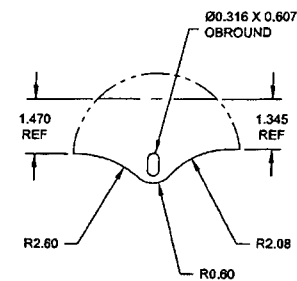
DESIGN	PH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3319	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	N
DATE	12.03.13	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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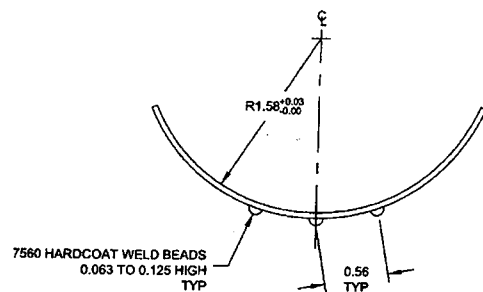
DETAIL K
SCALE 2X
B8-2
C4-3
C6-3



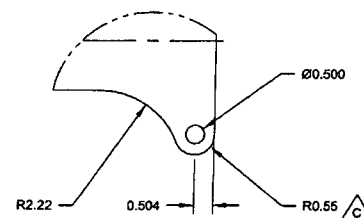
DETAIL F
SCALE 2X
B8-2



DETAIL J
SCALE 2X
B8-2
C7-3



SECTION H-H
SCALE 4X
B4-2
B3-3
B6-3



DETAIL G
SCALE 2X
B8-2
C2-3
C6-3

RELEASED
2012-02-16
412.03.16

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	P	DRAWING NO.	REV. C
MFG. APPR.	D	D3319	SHEET 4 OF 4
APPROVED	J	TITLE	SCALE
DE APPR.	J	WEARPLATE	NTS
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